

21

Date: Wednesday, 5/16/2007 8:13:12 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 32372		Part Number	: D35471	
Estimate Number	: 12530		Drawing Number	: D3547	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 5/16/2007 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/22/2007	
Previous Run	: 31124		Qty:	10 Um: Each	
Written By	: <u>JLJ</u>				
Checked & Approved By	: <u>JLJ</u>				
Comment	: Est Rev:A New Issue 06-09-18 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S125	2024-T3 .125 sheet	
		Comment: Qty.: 0.0557 sf(s)/Unit Total : 0.5565 sf(s) 2024-T3 .125 Sheet (M2024T3S0125) Batch: <u>4102087</u>	SAD 07/06/01
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3547 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> ****Ensure Grain Direction is Correct****	SAD 07/06/01 (16)
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/06/01 (16)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	SAD 07.06.04 (10)
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Bend as per Dwg D3557	SBS 07/07/12 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



(cont'd)

Comment: INSPECT WORK TO CURRENT STEP

En 07/07/12 -10

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AS 07-07-17

X10

8.0 POWDER COATING

POWDER COATING



m 101575

10

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL/M/07-07-17

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 07/07/17 10

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC7/18 10

11.0 QC21

FINAL INSPECTION/W/O RELEASE



07.07.18 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JM 07-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32372
Description: Bracket	Part Number:	D3547-1
Inspection Dwg: D3547	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

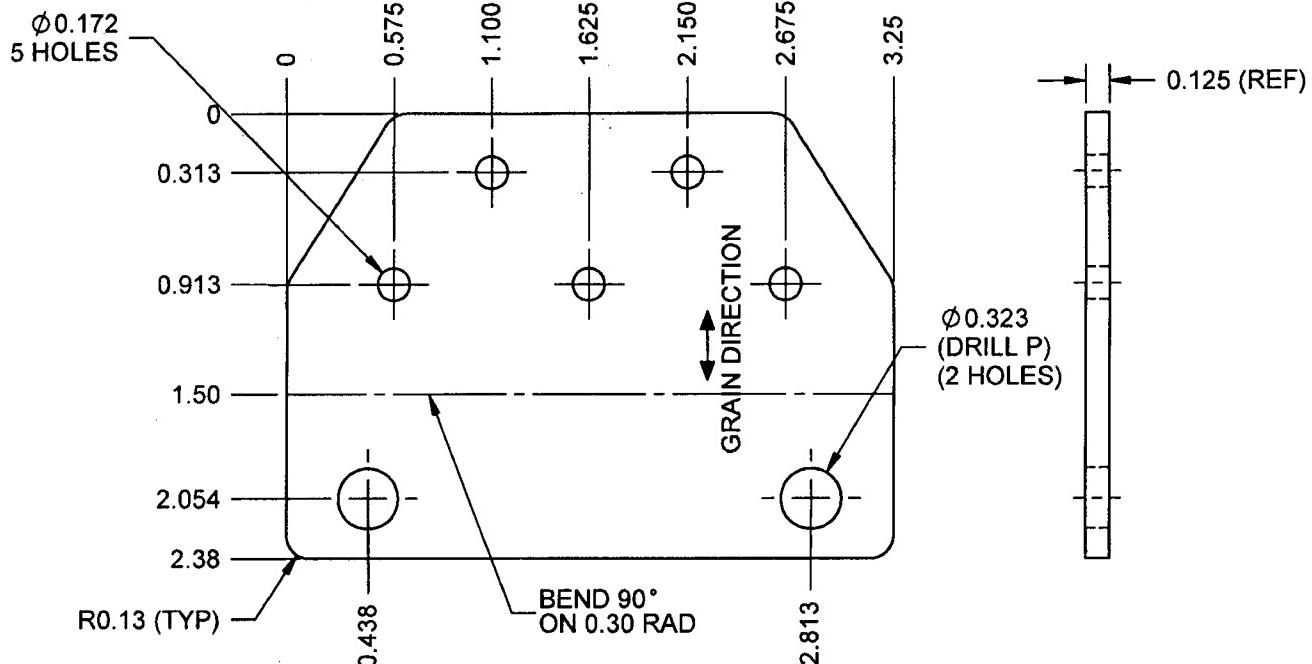
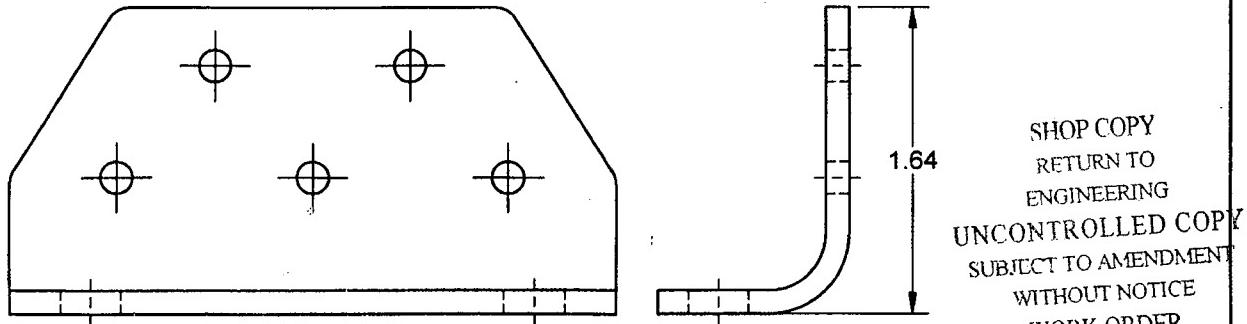
X First Article Prototype

Measured by:	SAD	Audited by:	SD	Prototype Approval:	N/A
Date:	01/05/01	Date:	01.06.04	Date:	N/A

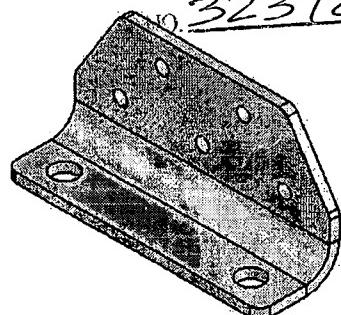
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	E

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D3547
DATE 06.10.06		REV. A SHEET 1 OF 1
		SCALE 1:1
REV A	DATE 06.10.06	DESCRIPTION NEW ISSUE

RELEASED
06.10.06**D3547-1F FLAT PATTERN****D3547-1 BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3547-1 USING FINE POINT PERMANENT INK MARKER

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